

Abstract

Page 1



Stop

Abstract

Cust Item ID:[illegible]**Customer:**

Reference:

Run Start

CL

Date: 11/04/21

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

**Insp.
Stamp**

Revision Nbr

D4149

C

100

0.00

Abstract

Waterjet

FLOW CNC Waterjet

304 . 128

Memo

0.00

Cut as per dwg D4149

Prog Rev: C

Dwg Rev: 1

Debutt as required

110

QC2- Inspect parts off machine FAI/FAIB

0,00

[illegible]

QC

Quality Control

Memo

0.00

B11-4-26

HB11-4-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68869

Thursday, April 21, 2011 12:45:51 PM



Page 2

Item ID: D4149-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Crosstube Lug Plate, Aft					
Start Date: 4/21/2011	Start Qty: 20.00		Cust Item ID:		
Required Date: 5/6/2011	Req'd Qty: 20.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120	QC8- Inspect parts - second check	0.00				auto			
		0.00		S 140467		200			
QC	Memo								

Quality Control

150	Identify as per dwg & Stock Location: 133	0.00				11/4/27		208	
		0.00							
Packaging	Memo								

Packaging

160	QC21- Final Inspection - Work Order Release	0.00						11/4/28	
		0.00							
QC	Memo								

Quality Control

11-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 12:45:48 PM

Page 1

Work Order ID: 68869

Parent Item: D4149-1

Parent Item Name: Crosstube Lug Plate, Aft

Start Date: 4/21/2011

Required Date: 5/6/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 11.03.03 as per revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S11GA

Purchased

No

100

sf

192.0000

0.1355

2.852632



1311-4-76

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

192

117494

192

117494

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

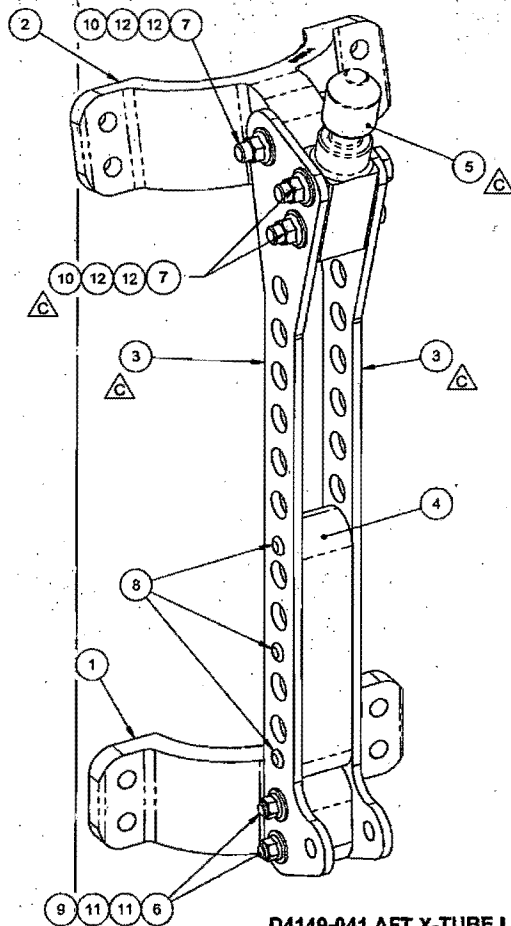
DART AEROSPACE LTD		Work Order:	68869
Description: Aft Crosstube Lug Plate		Part Number:	D4149-1
Inspection Dwg: D4149	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.132	X		V HB 62	
Ø0.191	+0.005/-0.001	.193	X		V	
Ø0.257	+0.006/-0.001	.260	X		V	
Ø0.38	+0.006/-0.001	.379	X		V	
0.380	+/-0.010	.378	X		V	
0.469	+/-0.010	.468	X		V	
0.310	+/-0.010	.310	X		V	
0.750	+/-0.010	.752	X		V	
3.25	+/-0.030	3.251	X		V	
0.65	+/-0.030	.650	X		V	
0.63	+/-0.030	.630	X		V	
5.46	+/-0.030	5.461	X		V	
3.80	+/-0.030	3.798	X		V	
2.13	+/-0.030	2.13	X		V	
1.313	+/-0.010	1.316	X		V	
0.625	+/-0.010	.626	X		V	
0.375	+/-0.010	.377	X		V	
1.175	+/-0.010	1.179	X		V	
0.752	+/-0.010	.752	X		V	
1.588	+/-0.010	1.590	X		V	
1.587	+/-0.010	1.589	X		V	
11.15	+/-0.030	11.150	X		PROW 502	
0.750	+/-0.010	.760	X		V	
1.55	+/-0.030	1.555	X		V	
1.12	+/-0.030	1.127	X		V	
8.42	+/-0.030	8.42	X		P	
2.70	+/-0.030	2.70	X		V	
0.125	+/-0.010	.117	X		V	

Measured by:	B	Audited by:	S	Preliminary Approval:	N/A
Date:	11-4-21	Date:	11/04/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	



D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs

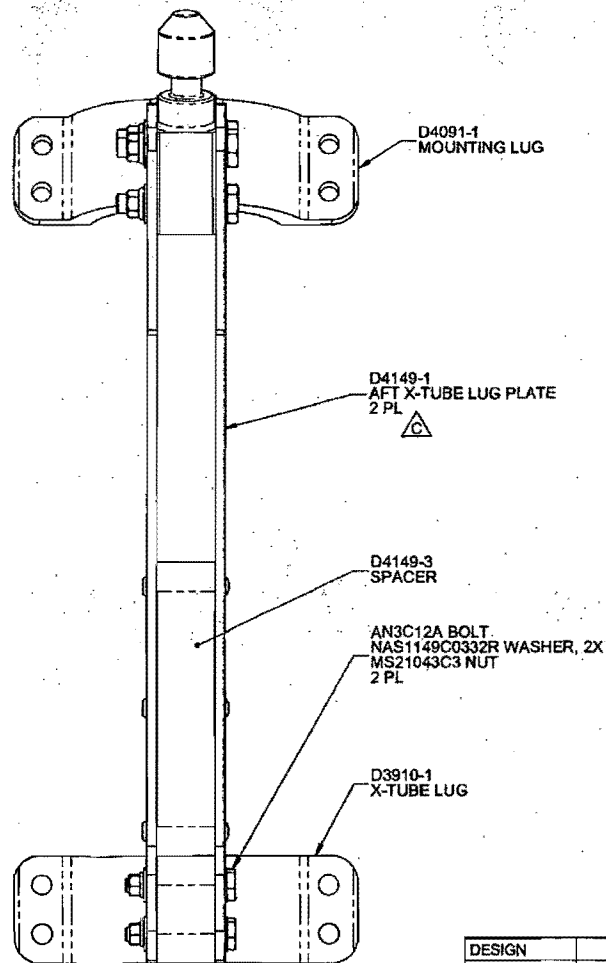
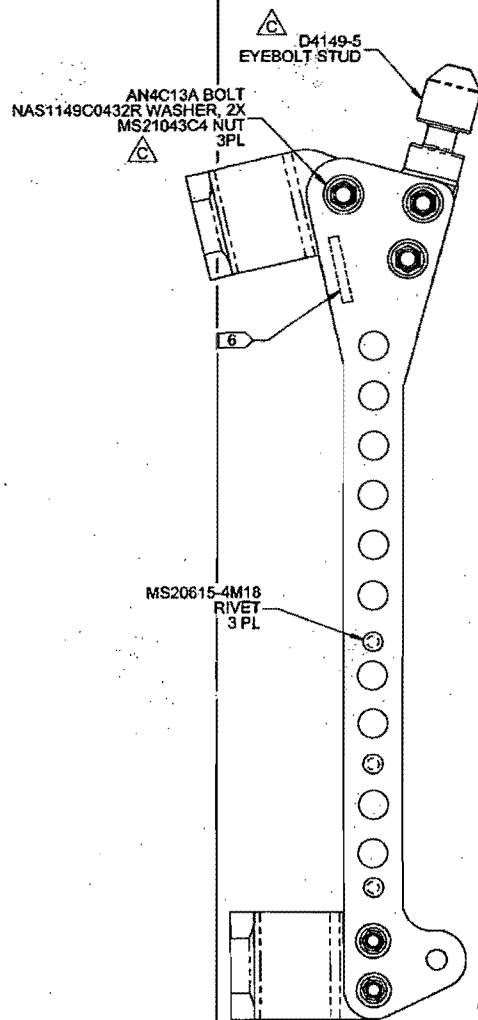
ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68867

C2104/121

LEASED
2011-02-26
JAN

C	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN3C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, D7-2)	SC	11.02.22
B	MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3910-5 (ZN D3-1 & D7-2); REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D8-3); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS TO BE USED ONLY FOR THE PURPOSES AND IN THE MANNER SPECIFIED HEREIN. IT IS NOT TO BE REPRODUCED, COPIED, OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

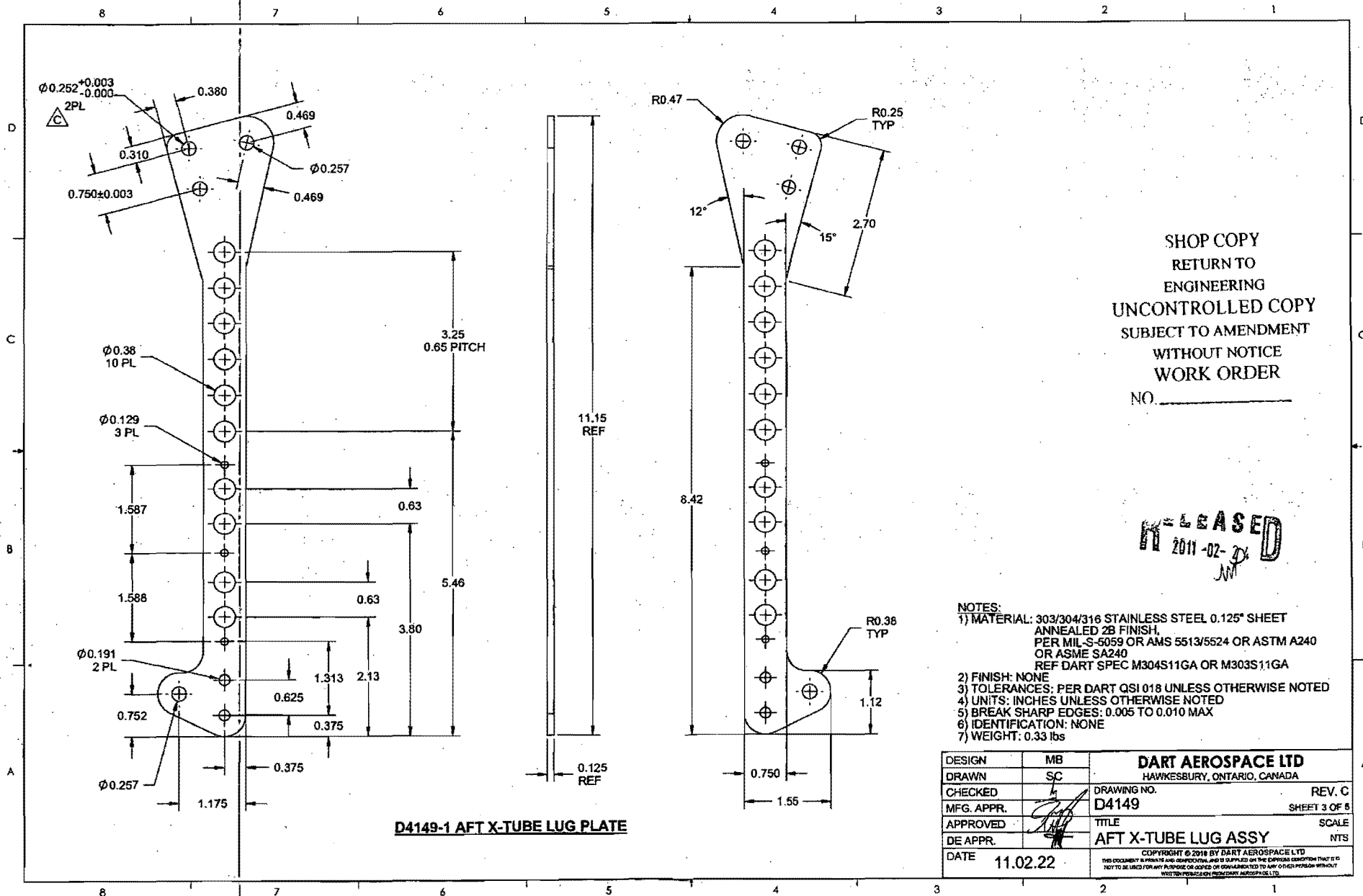


D4149-041 AFT X-TUBE LUG ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68869

RELEASED
2011-02-24
MP

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO. D4149	REV. C
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER THAN THE SPECIFIC PURPOSE FOR WHICH IT WAS SUPPLIED WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

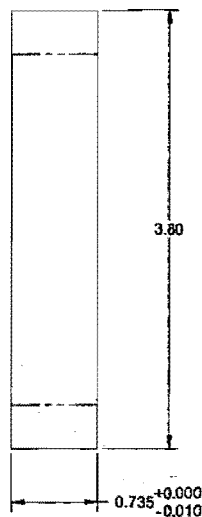
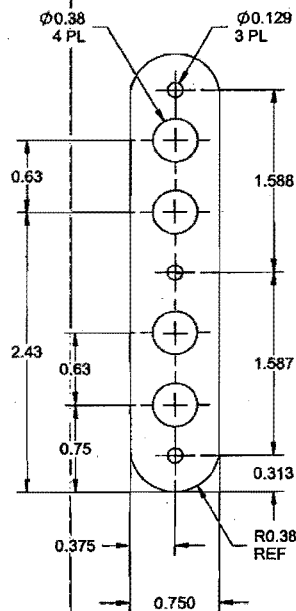


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

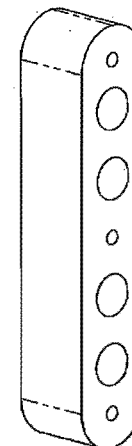
RELEASED
2011-02-24

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET
ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240
OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.33 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4149-3 SPACER



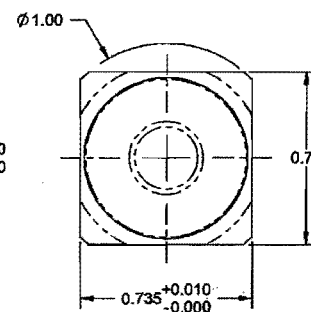
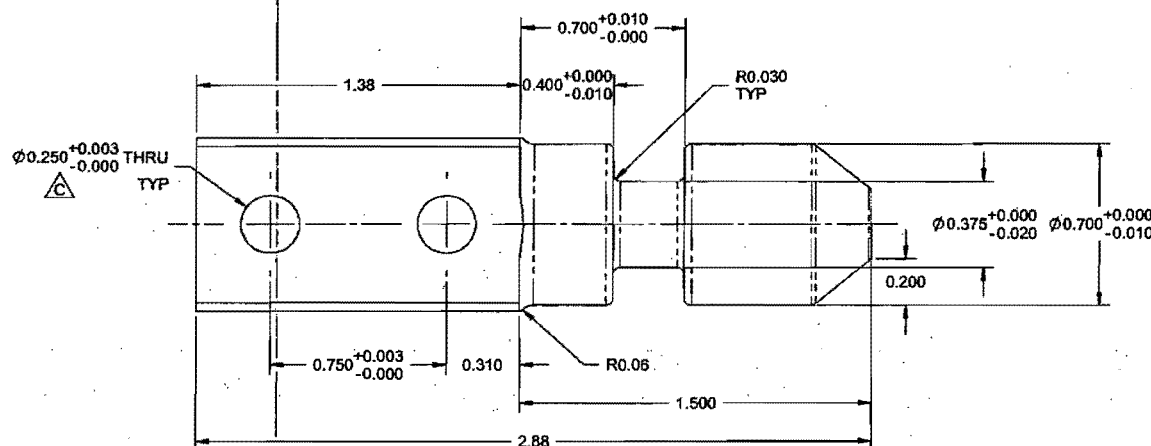
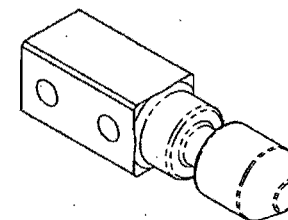
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68809

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4149-5 EYEBOLT STUD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68869

RELEASED
2011-02-24

- NOTES:
1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.32 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

.....